

Date: Wednesday, 04/02/2009 10:32:51 AM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 45487		
Estimate Number	: 10498		
P.O. Number	:	Part Number	: D2739
This Issue	: 04/02/2009	S.O. No.	: D2739 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	: 45373	Material	:
Written By	:	Due Date	: 11/02/2009
Checked & Approved By	: <u>JUL 09.02.04</u>	Qty:	3 Um: Each
Comment	: Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Extrusion 'I Beam' thin	<i>Aum 9-2-y</i>
		Pick: Qty Part Number Description Batch 1 D2600-5 Web <u>B - 38589</u>	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739.	
		2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	
		3-Use uni-bit to open holes to finish size as per Dwg D2739.	
		4-Bevel Fwd end of extrusion and Deburr holes and ends.	
		5-Dburr	<i>Aum 9-2-y</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>BF 0902/04</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEB

Job Number: 45487

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



AUM 9-2-4



(8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M (8) 9-2-4

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: ~~L-60~~ AUM 9-2-4

(8)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/05 d/j

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-02-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

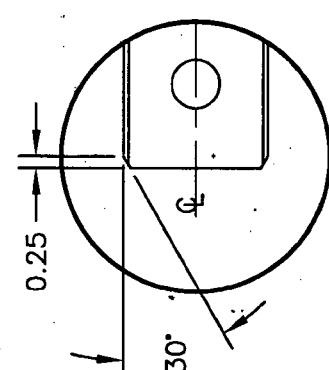
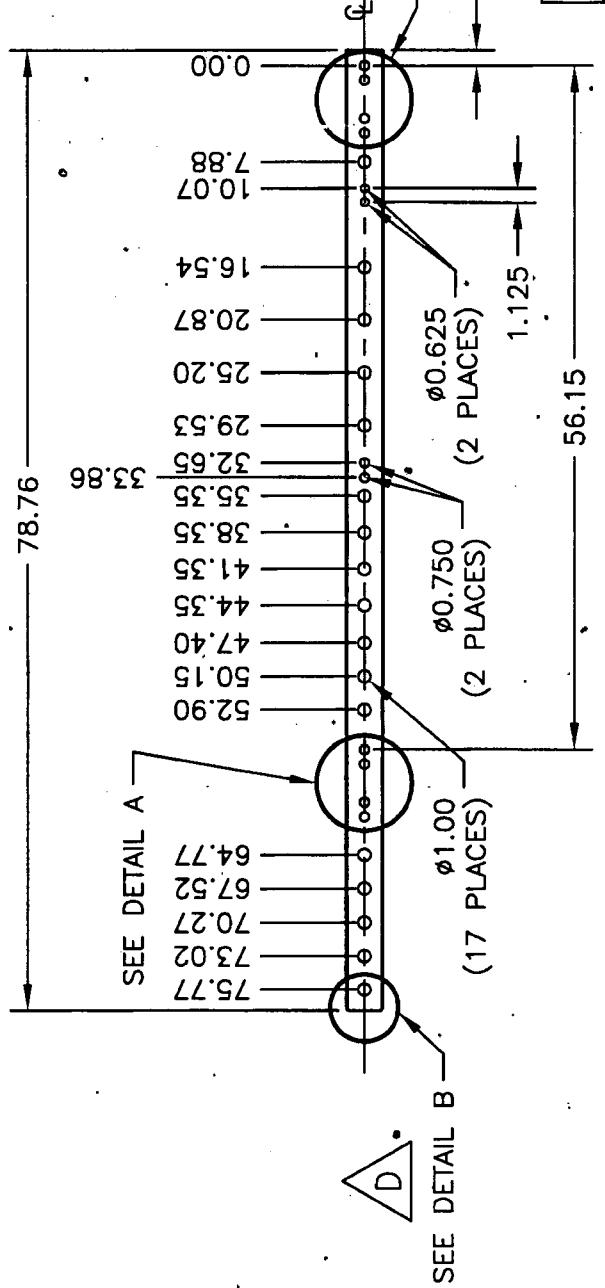
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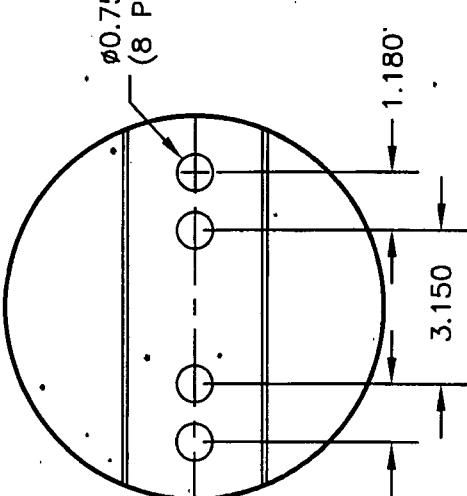
**DART**

DESIGN <b>PH</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D2739</b>	REV. D SHEET 1 OF 1	
DATE <b>07.05.29</b>	TITLE <b>WEB</b>		SCALE <b>1:15</b>	
A	<b>98.04.16</b>	NEW ISSUE		
B	<b>98.11.18</b>	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS		
C	<b>06.01.05</b>	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS		
D	<b>07.05.29</b>	ADD BEVEL TO FWD END; ADD DETAIL B		

07-08-02 - ff



D2739 WEB



DETAIL A

↑  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUSPECT TO AUT'DIMENT

**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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